



POLYMERIZATION OF VINYL MONOMERS

RELEASED _____ DATE _____

Ship Via:

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	HAAS 4 Axis	6 pcs	8/15/19	1.00	1.51		HAAS - 1		19-08-26
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	6 pcs	8/15/19	0.00	0.00		QC 2 - 1		19-08-26
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

Container No: S209025

Part: D2362 - 3
Lot No: 198691
Serial No/Batch: S209025

Inspection:
Inspector:
Date:
Instructions: Various STC's

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1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
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www.dartaerospace.com

Date: 08/26/19

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120 QC 8	6 pcs	8/15/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	19-08-26
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
130 Small Fab - 2 - B4B	6 pcs	8/15/19	0.00 0.75	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Small Fab - 1 - B4B	19-08-26
				Small Fab - 2 - B4B	
140 Powdercoat - 1 White Gl(A)- B4B M193-59.	6 pcs	8/15/19	0.00 0.22	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
150 QC 3	6 pcs	8/15/19	0.00 0.00	Powdercoat - 3 - B4B	BR 19-8-27.
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	smb 19/8/27
				QC 3 - 59	

START: 8:30 O.U.T. 320° FINISH: 9:00

160 Small Fab - 3 - B4B	6 pcs	8/15/19	0.00 0.75	QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
170 QC 5	6 pcs	8/15/19	0.00 0.00	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
180 Packaging 3-1 - Stock - B4B	6 pcs	8/15/19	0.00 0.00	QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 -	

AUG 26 2019

AUG 27 2019

DAS
40
9-89

						B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	PC 57537
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	8/15/19	0.00	0.00		QC 21 - SA - 21	AUG 28 2019
						QC 21 - SA - 70	
						QC 21 - SA - 53	

Part Op 100 - (HAAS CNC vertical machine #1) 1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: — 2-Deburr per Descriptions: dwg D2362
110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Small Fab) Deburr
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
150 - (QC3- Inspect Part Finish)
160 - (Small Fab) Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362
Batch N138775
170 - (QC5- Inspect part completeness to step on W/O)
180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2265	Step Bracket	6 pcs (1 ea)	100-HAAS 4 Axis	
D2397-1	Rubber Cushion	6 pcs (1 ea)	160-Small Fab - 3 - B4B	2xS 1719 28-18x8190235
D2397-3	Rubber Cushion	6 pcs (1 ea)	160-Small Fab - 3 - B4B	2xS 1719 269-18x8190230

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D2265	6	49	0
160-Small Fab - 3 - B4B	D2397-1	6	27	0
	D2397-3	6	26	0

Part Specifications
Specifications could not be found.

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Job: _____		DISPOSITION				DEPARTMENT/PROCESS															
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐				Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :		Sequence #:		QTY Affected :		MRB (QS1042)															
Description Work Order Deviation						Disposition															
Root Cause						FAULT CATEGORY															
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
												Completed By									
						Lead hand / Supervisor															
						QC / QA Coordinator															

Job: <u>198691</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D2362-3</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>15/9/23</u>	Sequence #:	QTY Affected:		MRB (QS042) <u>INSP 12/19/23</u>			
Description Work Order Deviation		Disposition					
the Existing slot on D2362-3 at Rev.E interference, adjust slot dimension with attach Drawing		-> Acceptable per attach Drawing minor deviation Ret CAR 19-305					
Root Cause		Completed By <u>df 19-08-26</u>					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		Lead hand / Supervisor <u>D.e 19-08-26</u>					
		QC / QA Coordinator					
FAULT CATEGORY							
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☒ Finish ☐ Part Lost/Missing ☐ Misread ☐	

